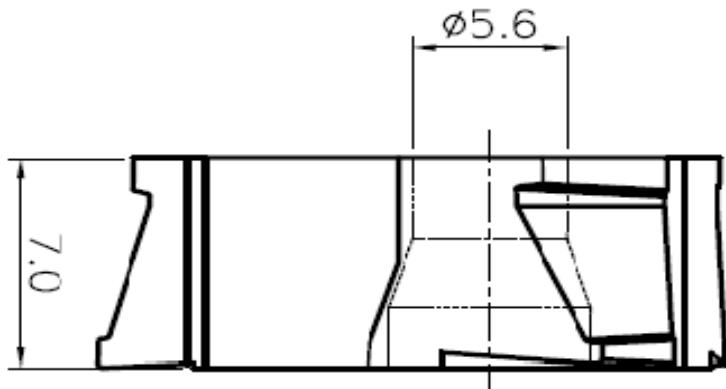


Insert TNF2-CFF6-HL ID-Ø13.0

A08-250



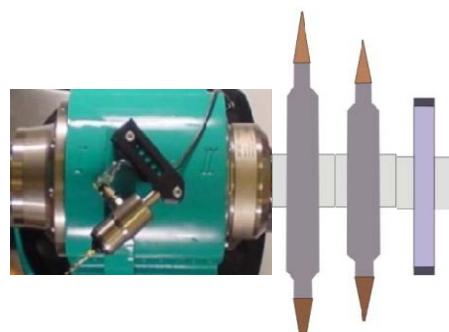
1. Cycletime for Production

Workpiece:	Triang. Blank ID-Ø13.0, T7.0 Material CARBIDE				
Operations	Probe A+Exc	Chipbreaker	Pregrinding	Finishing	Load
Feed [mm/Min]	2000	40	15	20	9000
Power [kW]		3	3	2	1
Cutting speed [m/s]		20	20	22	
Used wheels		1	2	3	
Grinding time [s]	45	47	210	180	20
Total cycle time	8 Min 23				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø150 D64
2	14EE1 Ø200 D76V20°
3	14EE1 Ø250 D46V20°



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3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM
 Control: Fanuc 310i
 Accessories: Loader STL6050, TTC clamping
 Responsible engineer: OP, 21.5.15

Coolant: Synthetic Oil, pressure 6 bar
 Software: Quinto 5

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